



工程指示 / 要求簡箋 ENGINEER INSTRUCTIONS(E.I.)

工程指示編號:	EI- 8935	修改版本:	-
	HK-		
工程編號:	J 861	工程名稱:	己連拿利
收件人:	羅小姐	發件人:	細佬
工程項目:	幕牆/欄河地盤Welding Test	日期:	14/05/2025

<input type="checkbox"/> 原合約工程包	<input type="checkbox"/> 原合約工程加 / 減賬 QT-	<input type="checkbox"/> 新工程報價 QT-
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信件批核號碼/圖紙參考編號:	批核模具圖紙編號:
客戶指示附件:	管理內部批簽署:

<input type="checkbox"/> 初步鋁料 B.M.	<input type="checkbox"/> 加工拆圖, 然後生產	<input type="checkbox"/> 尺寸表
<input type="checkbox"/> 正式鋁料 B.M.	<input type="checkbox"/> 技術上資料/指示	<input type="checkbox"/> 報價
<input type="checkbox"/> 配件 B.M.	<input type="checkbox"/> 樣辦或貨品說明書	<input type="checkbox"/> 分判合約
<input type="checkbox"/> 其他:		

內容: 請按附頁資料做Weld Test 100%目測 10%磁粉 時間會由地盤呀明打電話回公司約時間
完成上列要求日期: 28/05/2025

國內

<input type="checkbox"/> 生產技術總監	<input type="checkbox"/> 連附件	<input type="checkbox"/> 技術部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 生產部	<input type="checkbox"/> 連附件
<input type="checkbox"/> 採購部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 生產統籌部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 報關組	<input type="checkbox"/> 連附件
<input type="checkbox"/> 質檢部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 會計部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 機械設計部	<input type="checkbox"/> 連附件
<input type="checkbox"/> 香港辦	<input type="checkbox"/> 連附件	<input type="checkbox"/> 其他:			

香港

<input type="checkbox"/> 行政部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 會計部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 統籌部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 工程部	<input type="checkbox"/> 連附件
<input type="checkbox"/> 採購部	<input type="checkbox"/> 連附件	<input type="checkbox"/> QS部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 地盤管理	<input type="checkbox"/> 連附件	<input type="checkbox"/> 維修部	<input type="checkbox"/> 連附件

*發件人簽署:	*組別成員批核簽署:
傳遞編號:	項目經理簽署: 



METHOD STATEMENT

Magnetic Particle Test of Welds

(BS 6072:1981 / BSEN 1290:1998 / BSENISO 9934-1:2001/2016 / BSENISO 17638:2009 / 2016)

Introduction

This method statement described the procedure for magnetic particle test of fusion welded joints to detect surface-breaking flaws, particularly cracks. It can also detect flaws just below the surface, but sensitivity diminishes rapidly with depth.

The method statement in accordance with the requirement of BS 6072:1981 / BSEN 1290:1998 / BSENISO 9934-1:2001/2016 / BSENISO 17638:2009 / 2016.

1. Acceptance criteria & Sampling

The acceptance criteria and sampling shall be in accordance with the project specification or specified by client.

2. Competent Test Person

As a minimum requirement, the personnel performance magnetic particle test in accordance with BSENISO 9712 Level 2 or equivalent of the method.

3. Equipment

3.1 For measuring the various parameters and features of weld, the following equipment shall be used:

1. Welding gauge / Profile gauge
2. Measuring Tape / 150mm Steel Rule
3. White Light Meter
4. Tempilstik 50°C
5. Hand torch / Portable black Light (for fluorescent method)
6. Permanent magnet / Electromagnet
7. Magnetic Field Indication & Magnetic Flow Test Piece
8. Detecting Media & Contrast Paint (for Colour contrast Method)

4. Viewing conditions

4.1 For Colour Contrast Method:

The area under inspection shall be evenly illuminated at a level of not less than 500 Lux daylight or artificial light.





5 Procedure

- 5.1 Check the weld cap & 10mm either side of weld as welded, cleaned & free from scale, oil, grease, weld spatter, machining marks, dirt, heavy and loose paint and other foreign matter. The coated parts may be tested, provided the coating forms a thin (not more than 50 μ m), coherent layer, tightly adhering to the surface and not essentially the same colour as the particles to be used.
- 5.2 Visual inspection check that the dimension comply with the drawing / specification and any visually defect need to be recorded.
- 5.3 Apply thin even layer of white contrast paint on the area to be tested. Wait till it dries. (for colour contrast method)
- 5.4 Position the yoke oriented at 45° from the weld axis with pole distance and with an overlap distance of at least 1/2 of the pole distance for the whole length of the weld.
- 5.5 Verify the adequacy and direction of magnetic field by use of magnetic field indicator.
- 5.6 Apply the magnetizing force simultaneously while applying the magnetic particle over the weld and adjacent 10mm. Visually inspect the surface for any indication while the magnetizing force at a light intensity level of 500 Lux. Verify the light intensity by using a calibrated white light meter.
- 5.7 Repeat step 5.4 to 5.6 subsequently for the whole length of the weld.
- 5.8 Evaluate all indications whether relevant or non-relevant. To determine whether the indication is relevant or non-relevant, remove the particles attracted to the leakage field area, after the magnetizing force is removed. Visually inspect the area for any irregularities, then re-magnetize, apply the particles and re-inspect.
- 5.9 Use the standard worksheet to record down all information and result for the test.

6 Record

Indications may be classified as crack-like flaws, inclusions, rounded indications or linear indications, depending on the requirements of the acceptance criteria. All unacceptable indications stated in acceptance criteria shall be record and report. The test results shall be recorded in a standard form with all reference drawings attached, photographs will be attached if specified.





METHOD STATEMENT

Visual Examination of Welds

(BS 5289:1976 / BSEN 970:1997 / BSEN ISO 17637:2011 / 2016)

1. Introduction

This method statement described the procedure for visual inspection of fusion welded joints in accordance with the requirement of BS 5289 : 1976 / BSEN 970 : 1997 / BSEN ISO 17637:2011 / 2016.

2. Acceptance criteria & Sampling

The acceptance criteria and sampling shall be in accordance with the project specification or specified by client.

3. Equipment

For measuring the various parameters and features of weld, the following equipment shall be used:

1. Welding gauge / Profile gauge
2. Measuring Tape / 150mm Steel Rule
3. White Light Meter
4. Magnifying lens with 2X / Mirror

4. Viewing conditions

- 4.1 The surface to be inspected shall be have a minimum white light intensity of 500 lux.
- 4.2 Visual examination shall be made with the eye at within 600mm distance and at angle of not less than 30° to the surface being examined. To confirm or verify doubtful imperfection may be carried out by using a hand magnifying lens.

5. Procedure

The following items shall be checked against the acceptance criteria.

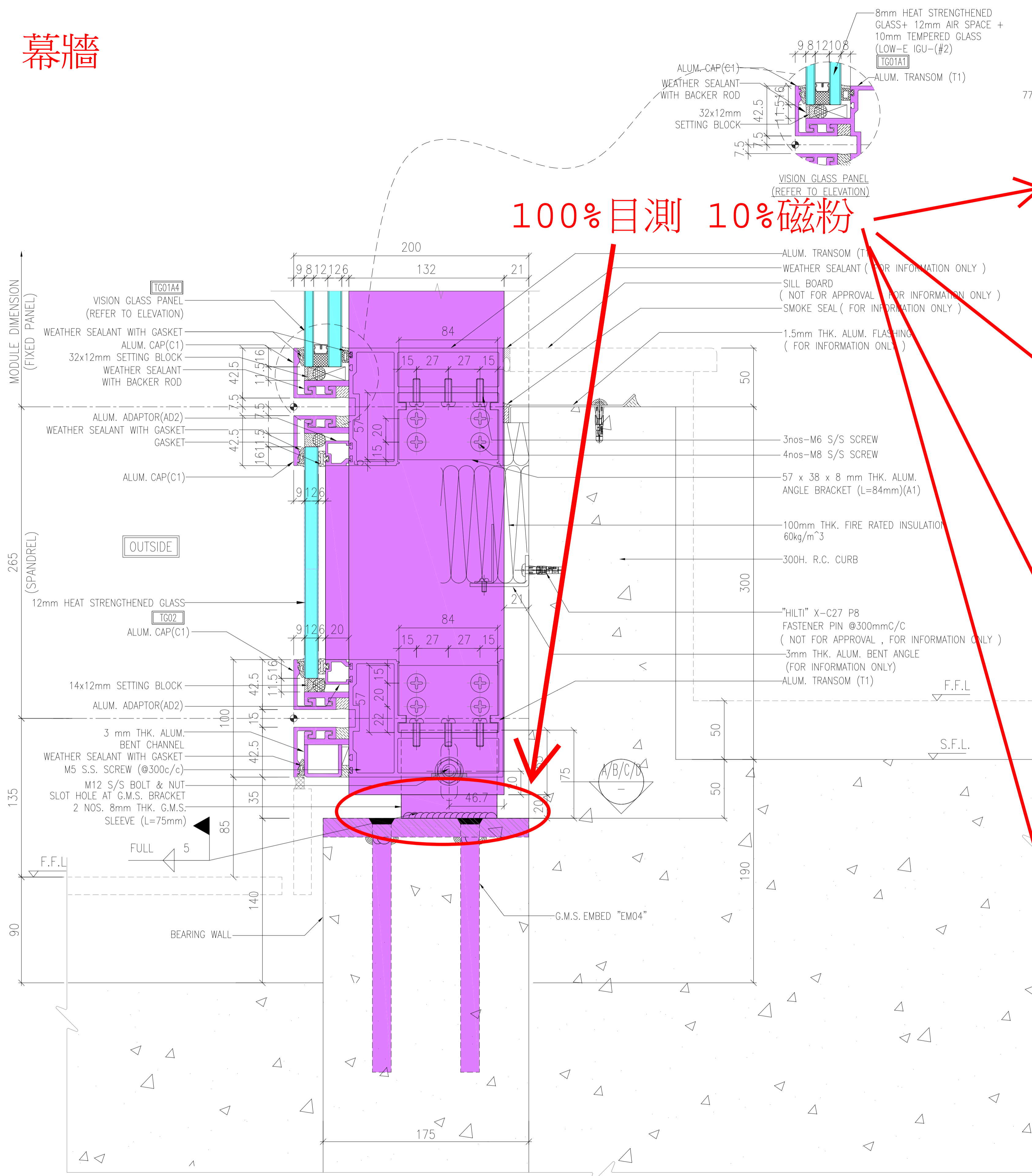
- 5.1 *Cleaning and dressing*
- 5.2 *Penetration and root inspection*
- 5.3 *Weld contour and reinforcement*
- 5.4 *Weld width and overlap*
- 5.5 *Undercut and Stray arcing and other weld flaws*

6 Record

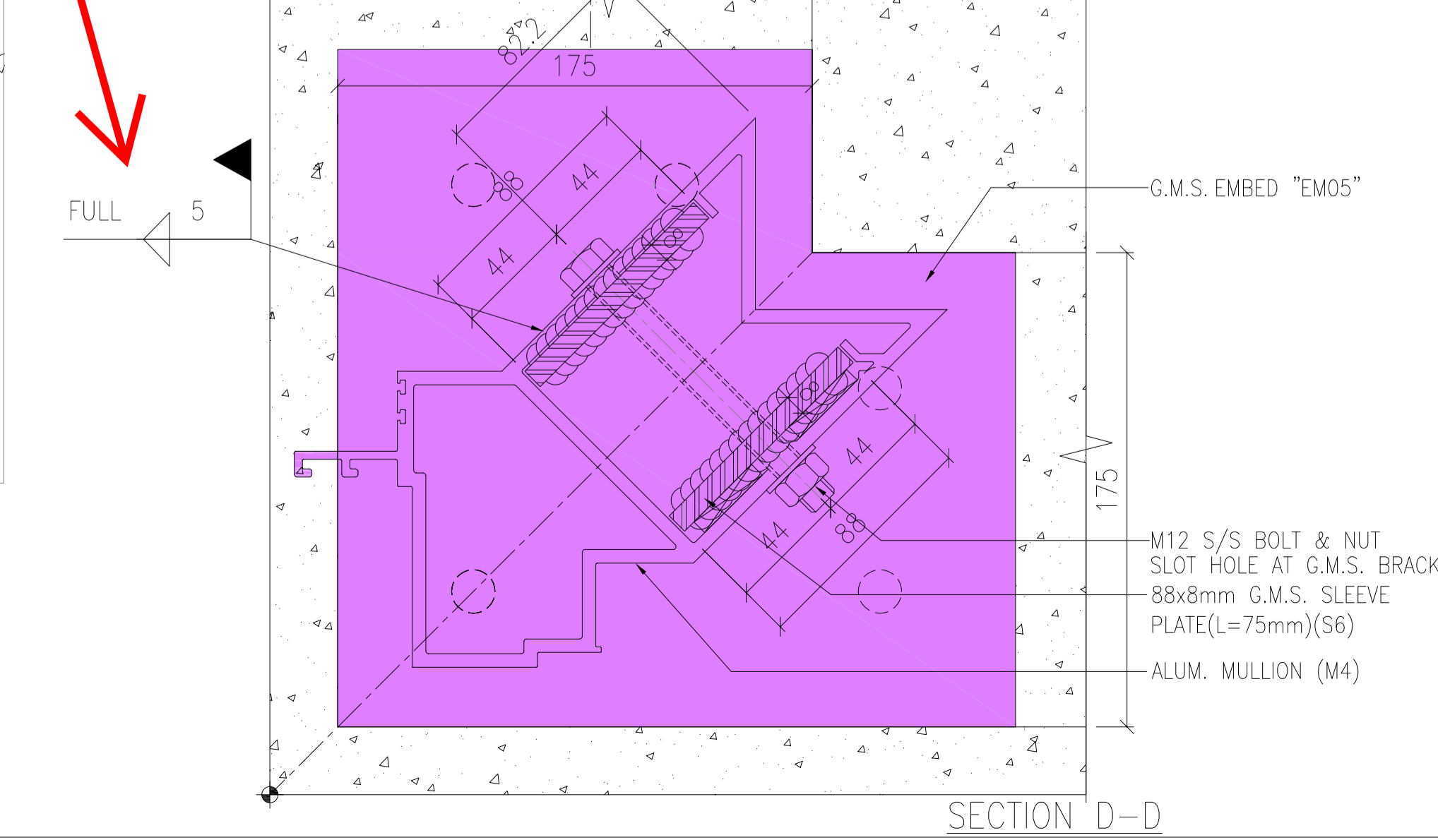
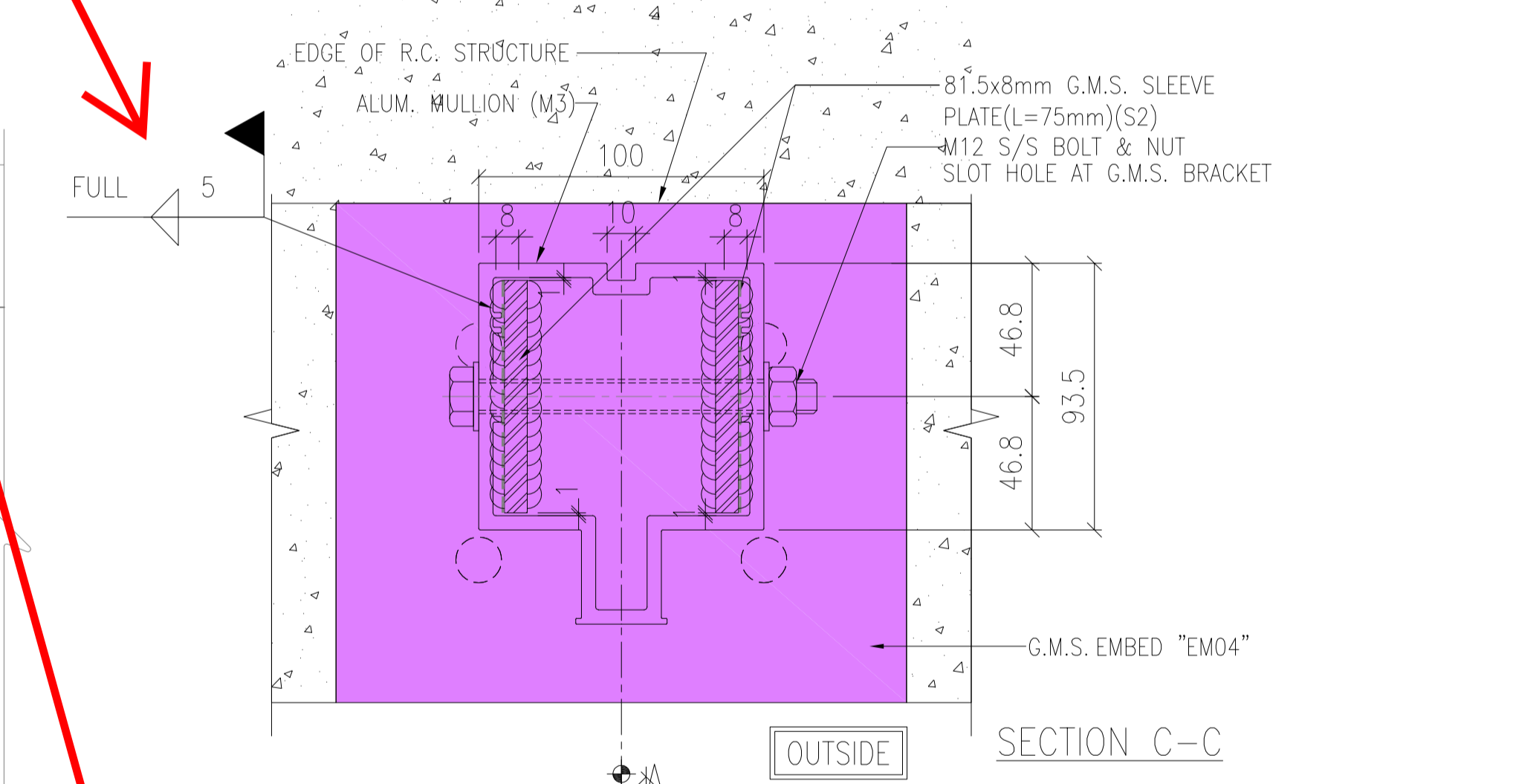
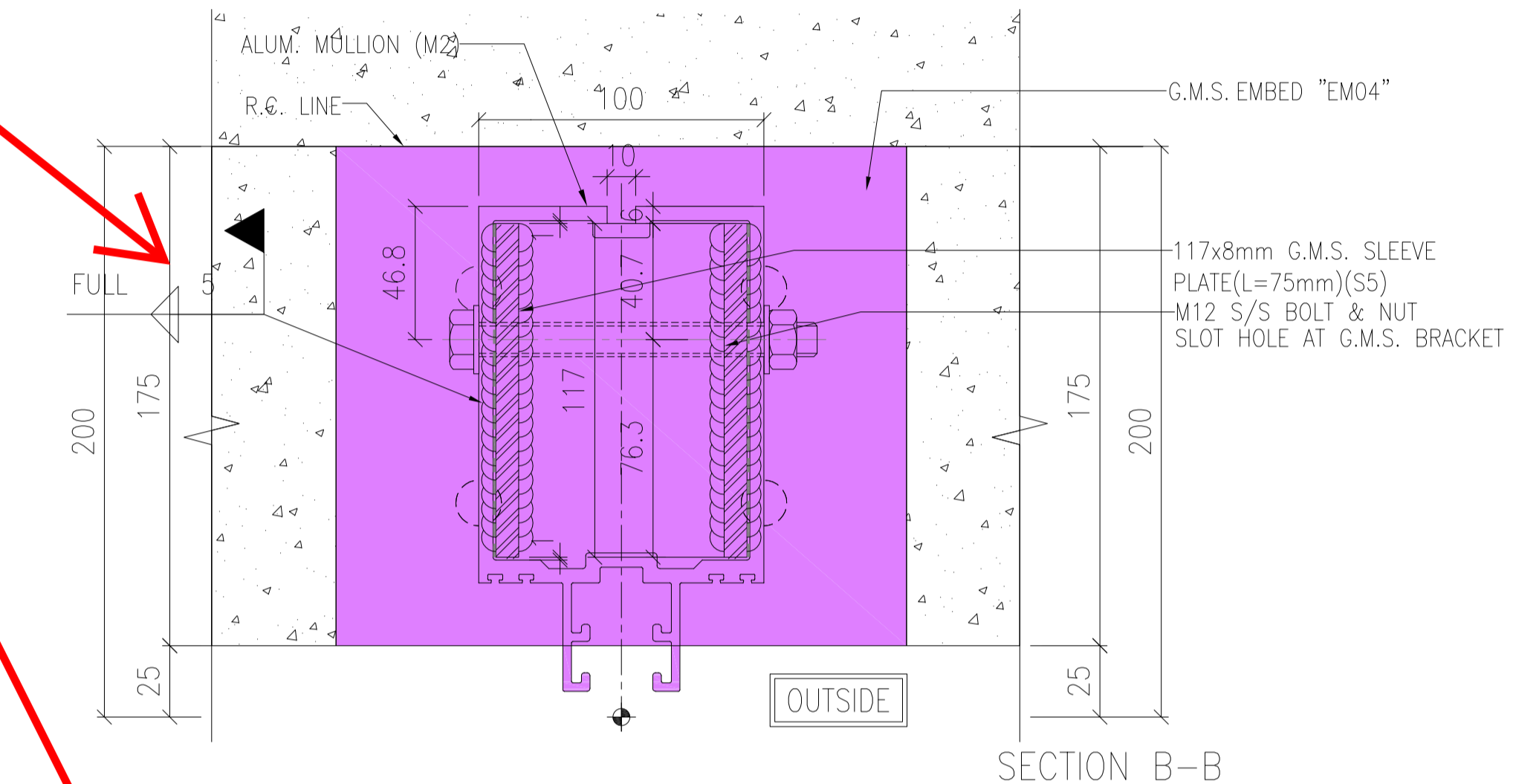
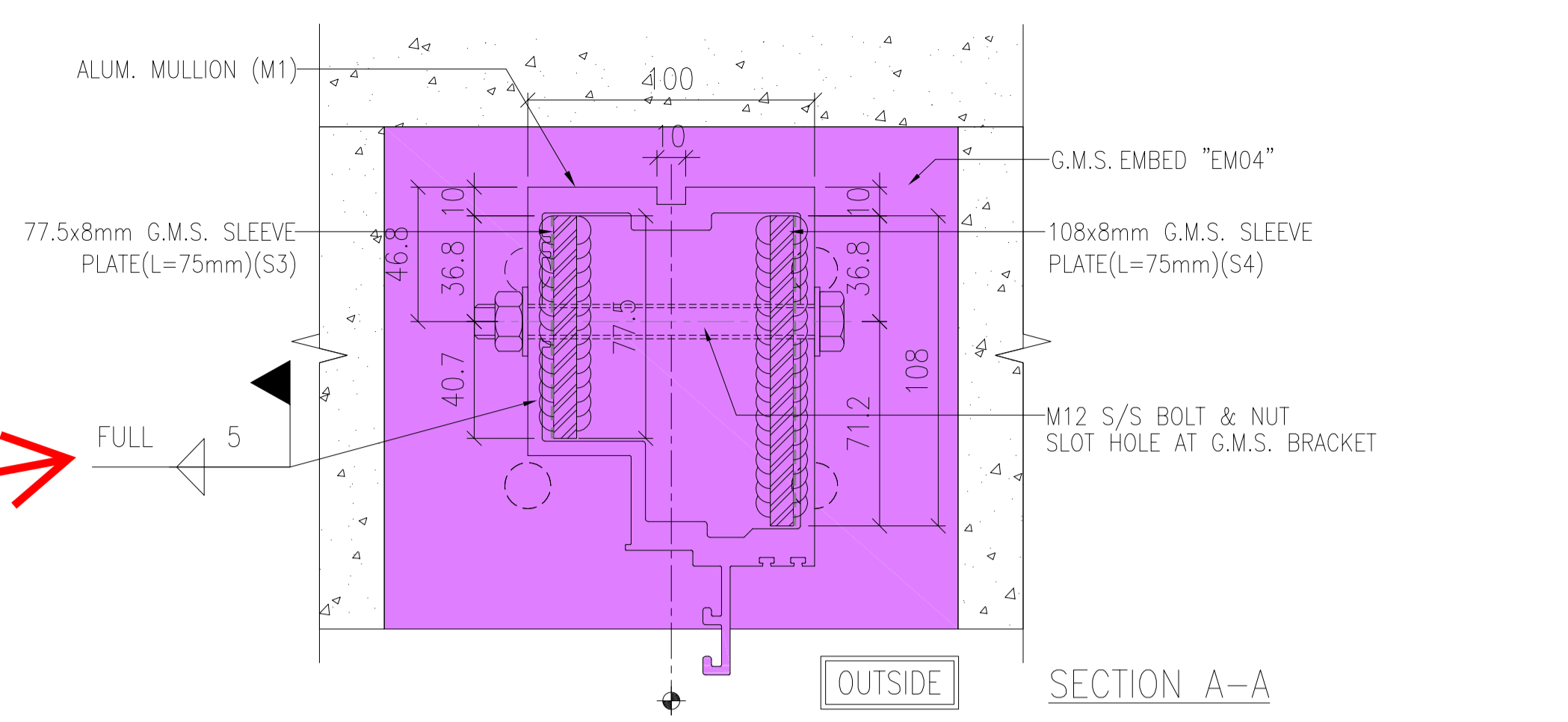
The test results shall be recorded in a standard form.



幕牆



100%目測 10%磁粉



1 TYPICAL TRANSOM DETAIL
6006 CURTAIN WALL
(BK7)

NOTE :
 1. ALL DIMENSIONS ARE IN mm.
 2. ALL ELEVATIONS ARE VIEWED FROM OUTSIDE.
 3. ALL DIMENSIONS TO BE VERIFIED ON SITE BEFORE FABRICATION.

LEGEND :
 X1 --- DETAIL MARK NO.
 X001 --- REFER SHEET NO.

1. F.F.L. --- FINISHED FLOOR LEVEL
 2. S.F.L. --- STRUCTURAL FLOOR LEVEL
 3. (R) --- REVERSED DETAIL

B.D. SUBMISSION

NO.	DATE	REVISED	BY

CLIENT :
MILLION BASE PROPERTIES LIMITED

ARCHITECT :
WONG TUNG & PARTNERS LIMITED
ARCHITECTS & PLANNERS

STRUCTURAL ENGINEER :
SYW & ASSOCIATES LTD.
CHARTERED ENGINEERS & AUTHORIZED PERSONS
邵賢偉建築工程師

MAIN CONTRACTOR :
顯利工程有限公司
HIEN LEE ENGINEERING CO., LTD.

美特鋁質有限公司
MIDI ALUMINIUM FABRICATOR LTD.
Units 6-8, Sunray Industrial Centre, 1/F
610 Cha Kwo Ling Road, Kowloon
Tel:23489211-4 Fax:(852)2727666

JOB NO. : J-861
PROJECT : PROPOSED RESIDENTIAL DEVELOPMENT AT NOS. 3-6 GLENEALY, CENTRAL, HONG KONG

TITLE : TYPICAL TRANSOM DETAIL FOR CURTAIN WALL

DATE : 6-SEP.-24 SCALE : 1:2 (A1)
 DRAWN BY : Asing CHECKED BY :
 DWG NO. : J861-BD-CW-6006 REV. : -

Digitally signed by LAI Shu Lun Benny
 RSE 2019
 01 November 2024

Received on 01 November 2024

Plan Approved
 (Digitally Signed)
 HO Wai-kuen
 Chief Structural Engineer
 for BUILDING AUTHORITY
 08 November 2024

Note: This plan has been processed on a curtailed check basis under the centralized processing system as promulgated in PNAP ADM-19. The duties of the authorized person, registered structural engineer and/or registered geotechnical engineer concerned as specified under section 4(3)(b) and the provision of section 14(2)(c) of the Buildings Ordinance are of particular relevance in this regard.

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- LEGEND:
- (X1) --- DETAIL MARK NO.
(X001) --- REFER SHEET NO.
1. F.F.L. --- FINISHED FLOOR LEVEL
 2. S.F.L. --- STRUCTURAL FLOOR LEVEL
 3. (R) --- REVERSED DETAIL

NO.	DATE	REVISED	BY

CLIENT :
MILLION BASE PROPERTIES LIMITED

ARCHITECT :
WONG TUNG & PARTNERS LIMITED
ARCHITECTS & PLANNERS

STRUCTURAL ENGINEER :
SYW SYW & ASSOCIATES LTD.
REGISTERED STRUCTURAL ENGINEERS & AUTHORIZED PERSONS
邵賢偉建築工程師

MAIN CONTRACTOR :
顯利工程有限公司
HIEN LEE ENGINEERING CO., LTD.

美特鋁質有限公司
MIDI ALUMINIUM FABRICATOR LTD.
Units 6-8, Sunray Industrial Centre, 1/F
610 Cha Kwo Ling Road, Kowloon
Tel: 23489211-4 Fax: (852) 27727666

JOB NO. : J-861

PROJECT :
PROPOSED RESIDENTIAL
DEVELOPMENT AT NOS. 3-6
GLENEALY, CENTRAL, HONG KONG

TITLE :
TRANSOM TYPICAL DETAIL

DATE : 10-Jul.-2024 SCALE : 1:4

DRAWN BY : SHAWN CHECKED BY : ANDAY

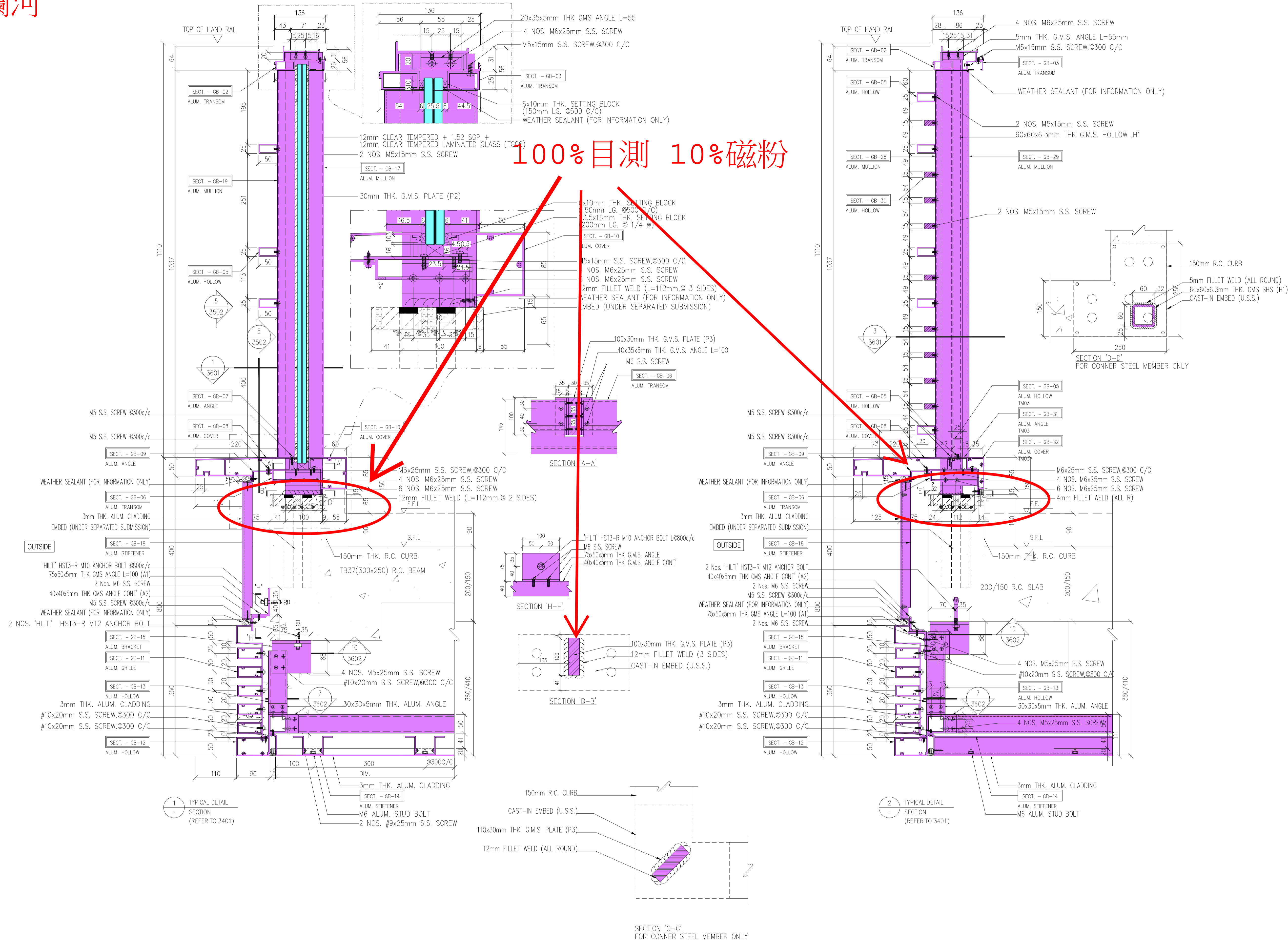
DWG NO. : J861-BD-GB-DT-3501 REV. : -

FOI
Digitally signed by
LAI Siu Lun Benny
RSE 2019
08 February 2025

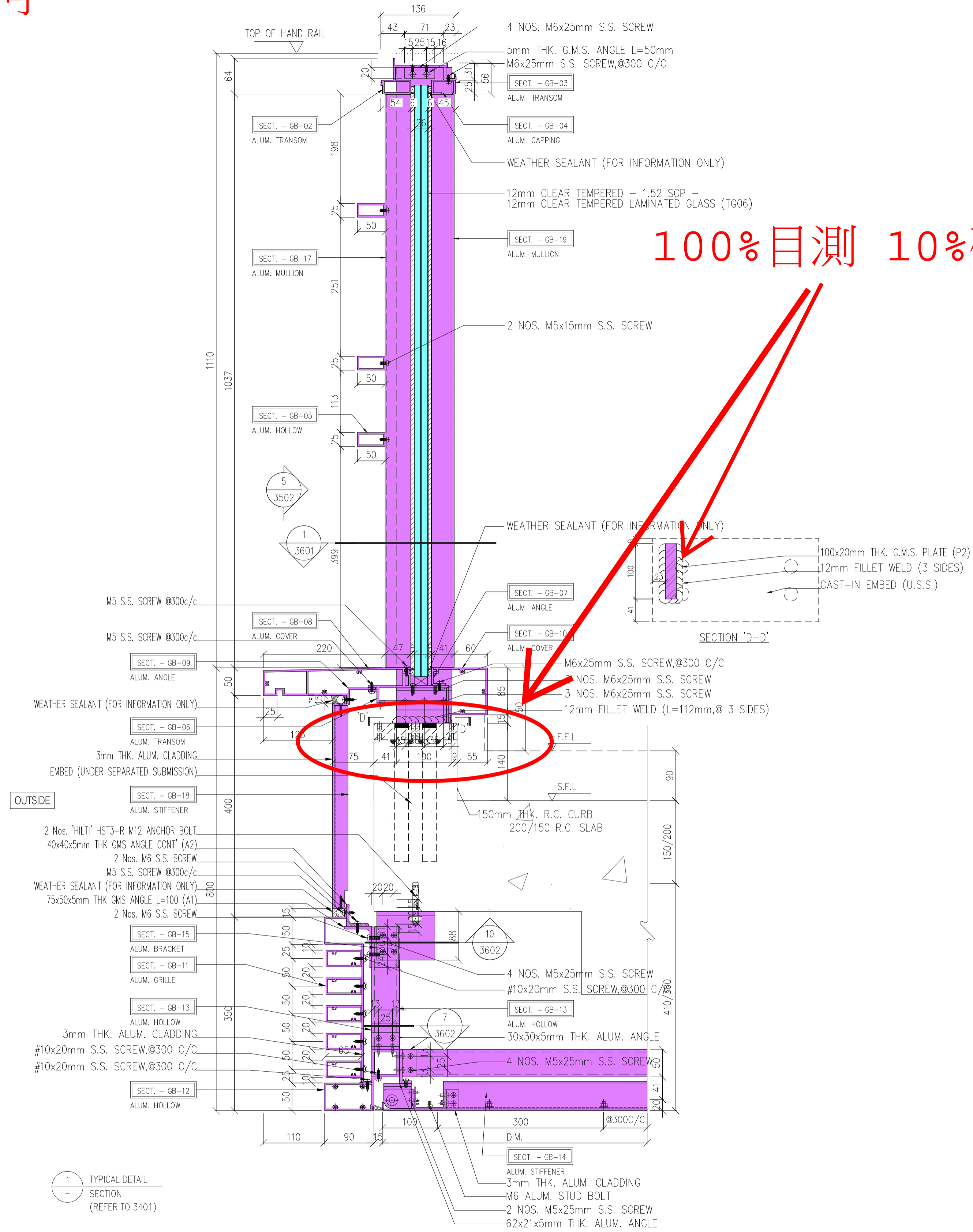
Received on
06 February 2025

Plan Approved
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HO Wai-kuen
Chief Structural Engineer
for BUILDING AUTHORITY
13 February 2025

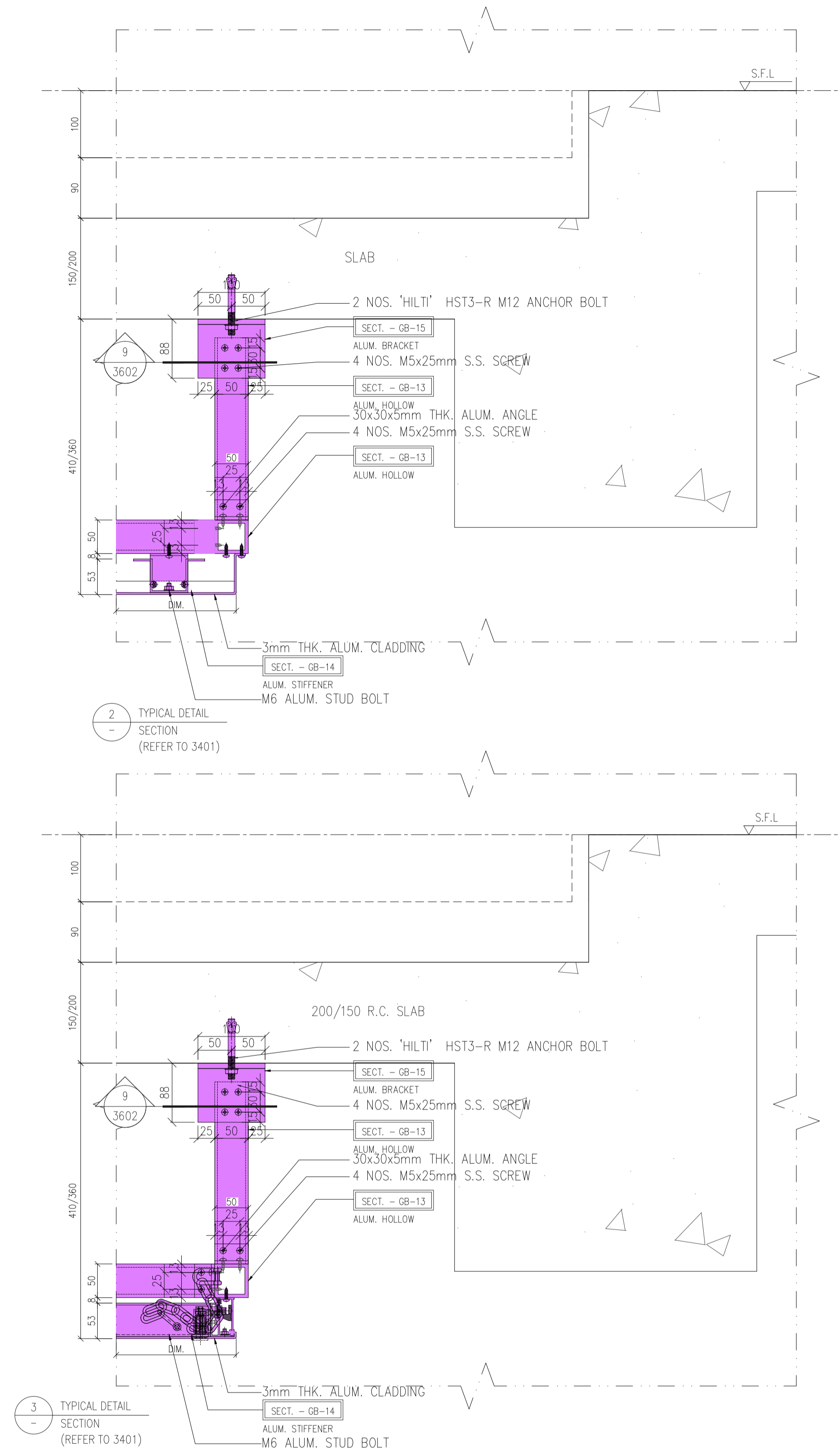
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欄河



100%目測 10%磁粉



B.D. REF : BD3 / 2024 / 18

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ARCHITECT :
WONG TUNG & PARTNERS LIMITED
ARCHITECTS & PLANNERS

STRUCTURAL ENGINEER :
SYW & ASSOCIATES LTD.
STRUCTURAL ENGINEERS & AUTHORIZED PERSONS
邵賢偉建築工程師

MAIN CONTRACTOR :
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JOB NO. : J-861

PROJECT :
PROPOSED RESIDENTIAL
DEVELOPMENT AT NOS. 3-6
GLENEALY, CENTRAL, HONG KONG

TITLE :
TRANSOM TYPICAL DETAIL

DATE : 10-Jul.-2024 SCALE : 1:4

DRAWN BY : SHAWN CHECKED BY : ANDAY

DWG NO. : J861-BD-GB-DT-3503 REV. : -

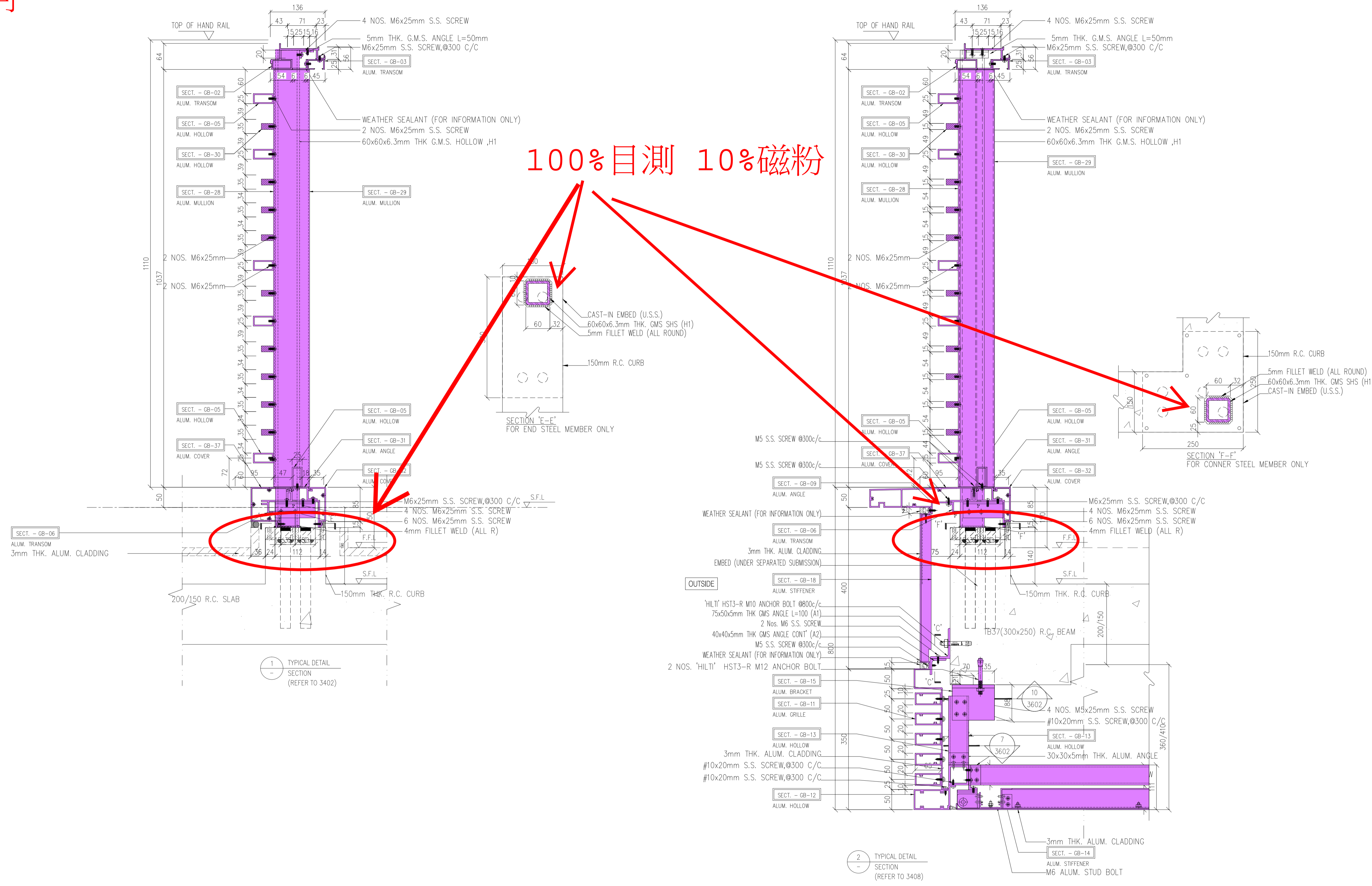
FO: Digitally signed by LAI Shu Lun Benny
RSE 2019
06 February 2025

Received on
06 February 2025

Plan Approved
(Digitally Signed)
HO Wai-kuen
Chief Structural Engineer
for BUILDING AUTHORITY
13 February 2025

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欄河



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 - 3. (R) --- REVERSED DETAIL

NO.	DATE	REVISED	BY

CLIENT: MILLION BASE PROPERTIES LIMITED

ARCHITECT: WONG TUNG & PARTNERS LIMITED ARCHITECTS & PLANNERS

STRUCTURAL ENGINEER: SYW & ASSOCIATES LTD. 邵賢偉建築工程師

MAIN CONTRACTOR: 顯利工程有限公司 HIEN LEE ENGINEERING CO., LTD.

MIDI ALUMINIUM FABRICATOR LTD. 美特鋁質有限公司
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JOB NO.: J-861
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TITLE: TRANSOM TYPICAL DETAIL

DATE: 10-Jul.-2024 SCALE: 1:4
 DRAWN BY: SHAWN CHECKED BY: ANDAY
 DWG NO.: J861-BD-GB-DT-3506 REV.: -

Digitally signed by LAI Shu Lun Benny
 RSE 2019
 06 February 2025

Received on 06 February 2025

Plan Approved (Digitally Signed)
 HO Wai-kuen
 Chief Structural Engineer
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 13 February 2025

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